

# Work Order ID 64398

Friday, December 03, 2010 3:06:33 PM



Page 1

Item ID: D4107-5

Accept



Setup Start



Revision ID:

Item Name: Spacer

Stop



Start Date: 12/3/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date: *10-12-3*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4107

B

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

*B10-12-17*

*18*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B10-12-17*



**Work Order ID 64398**

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Page 3

Item ID: D4107-5

Accept

Revision ID:

Item Name: Spacer

Start Date: 12/3/2010 Start Qty: 12.00

Required Date: 12/17/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg &amp; Stock Location: 120

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/20 10/12/21

10/12/21

MF 10-12-21

# Picklist Print

Friday, December 03, 2010 3:06:37 PM

Page 1

Work Order ID: 64398

Parent Item: D4107-5

Parent Item Name: Space



Start Date: 12/3/2010


Required Date: 12/17/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC  
10.12.03 as per dwg rev.B DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 		Purchased	No			100	sf	198.1340	0.0055	0.069474		12-10-17	

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT

160

116308

160

MAT21

38.134

113608

38.134

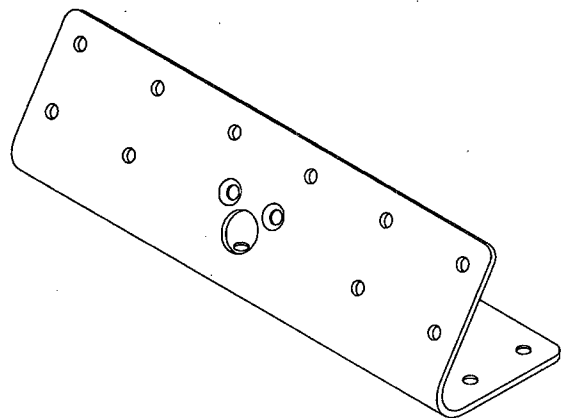
116308

(18)

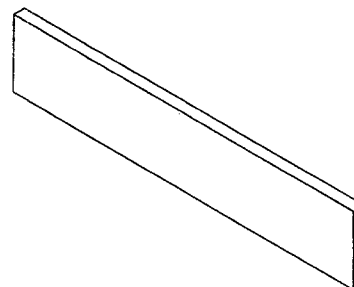


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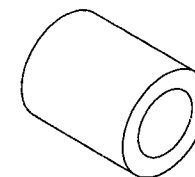
D  
C  
B  
A



**D4107-1 DOOR DOUBLER**



**D4107-5 SPACER**



**D4107-7 BALL STUD SPACER**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 64398

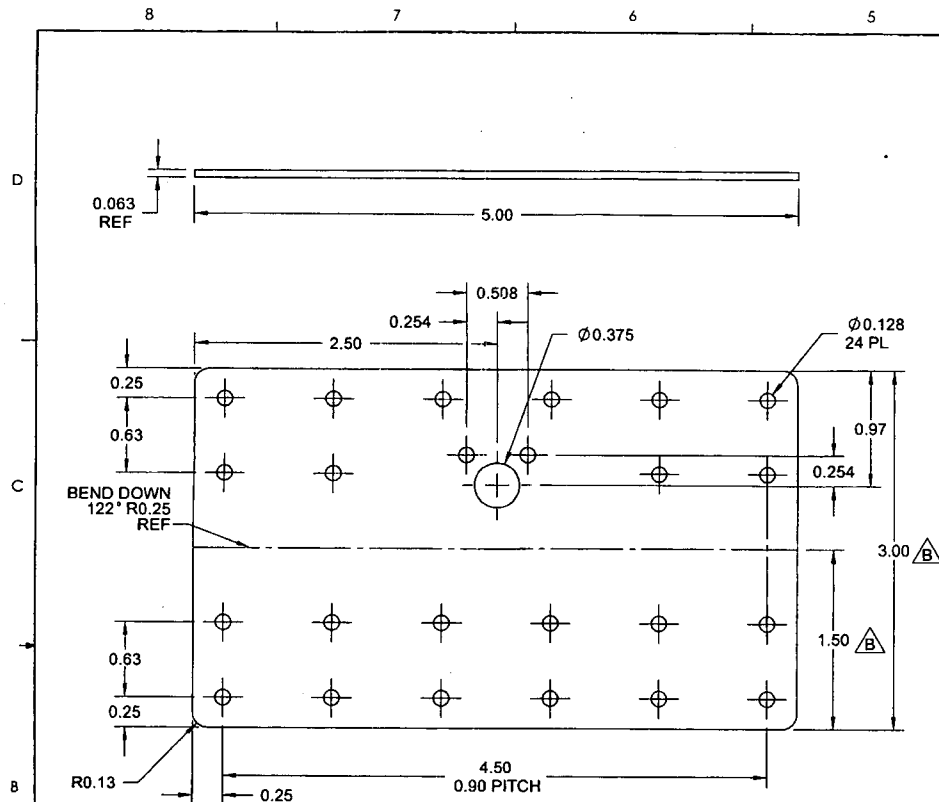
*PS 10-12-3*

RELEASED  
2010-11-30  
JPH

B	D4107: DIM 3.00 WAS 3.20 & 1.50 WAS 1.60 (ZN C5-2); 1.51 WAS 1.61 (ZN B2-2 & C3-2) TO IMPROVE INSTALLATION	JPH	10.11.01
A	NEW ISSUE	JPH	10.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.11.01		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4107</b> <b>DOUBLER &amp; SPACERS</b> <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			
		REV. B	SHEET 1 OF 3
		TITLE	SCALE
			NTS

D  
C  
B  
A

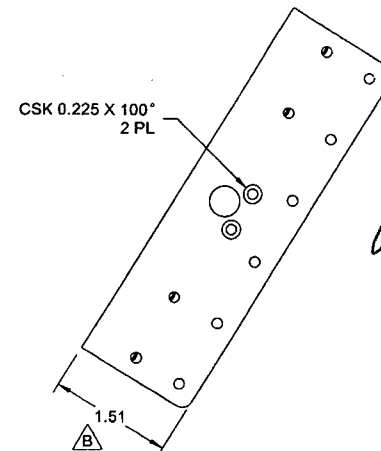
8 7 6 5 4 3 2 1



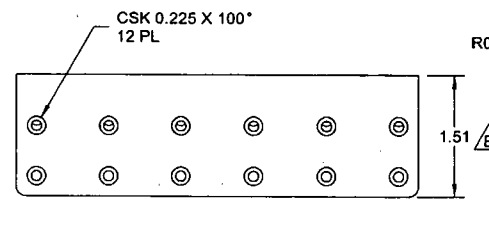
**D4107-1F FLAT PATTERN, DOOR DOUBLER**

**NOTES:**

- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-1: MAKE FROM D4107-1F.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -1: IDENT P/N D4107-1 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs



**VIEW A-A**

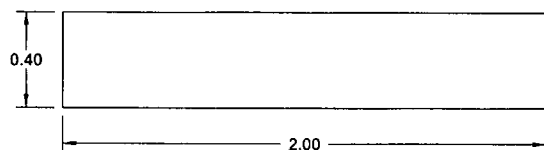
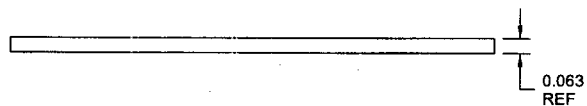


**D4107-1 DOOR DOUBLER  
(MAKE FROM D4107-1F)**

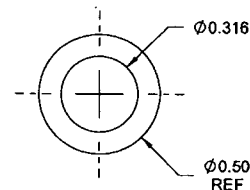
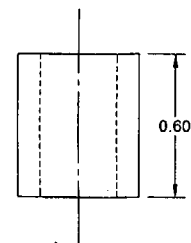
**RELEASED**  
2010-11-09  
JW

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DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4107</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE <b>DOUBLER &amp; SPACERS</b>	SCALE NTS
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DE APPR.	<i>[Signature]</i>	DATE <b>10.11.01</b>	

W1044398



**D4107-5 SPACER**



**D4107-7 BALL STUD SPACER**

**NOTES:**

- 1) MATERIAL -5: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S063  
OR  
ALUMINUM 2024-T3 SHEET 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 7: 303/304/316 STAINLESS STEEL ROUND BAR Ø0.50, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303R0.500 OR M304R0.500
- 2) FINISH -5: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-7: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4107-X & B/N PER QSI 044.
- 7) WEIGHT -5: < 0.01 lbs  
-7: 0.03 lbs

RELEASED  
2010-11-00

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DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4107</b>	REV. B SHEET 3 OF 3
MFG. APPR.	<i>[Signature]</i>	TITLE <b>DOUBLER &amp; SPACERS</b>	SCALE NTS
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DE APPR.	<i>[Signature]</i>		
DATE	10.11.01		